

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015775**Date Inspected:** 19-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Le Zhi Jiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # CROSS BEAM CB11

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB12

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB13

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB14

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This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB15

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB16

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB17

This QA observed ZPMC qualified welding personnel identified as 054459 / 500479 perform Flux cored Arc Welding (FCAW) Process on Weld joint CB3001A-017-014. ZPMC Quality Control Personnel (QC) identified as Mr. Lin chuan gang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132

This QA observed ZPMC qualified welding personnel identified as 500479 perform Flux cored Arc Welding (FCAW) Process on Weld joint CB3001A-017-005. ZPMC Quality Control Personnel (QC) identified as Mr. Lin chuan gang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-TC-U4b-F

During random in- process inspection, this QA inspector observed that Complete Joint Penetration (CJP) weld have root gap more than approved WPS. This QA marked the areas in question for the contractors QC to inspect and evaluate. The attached photos of these discrepancies are intended to capture the in-process workmanship being performed on this component. See attached pictures.

OBG # CROSS BEAM CB18

This QA observed ZPMC qualified welding personnel identified as 062447 perform Flux cored Arc Welding (FCAW) Process on Weld joint BP3051-001-007,008. ZPMC Quality Control Personnel (QC) identified as Mr. Cui Jun Jie was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 204342 perform Flux cored Arc Welding (FCAW) Process on Weld joint BP3055-001-007,008. ZPMC Quality Control Personnel (QC) identified as Mr. Cui Jun Jie was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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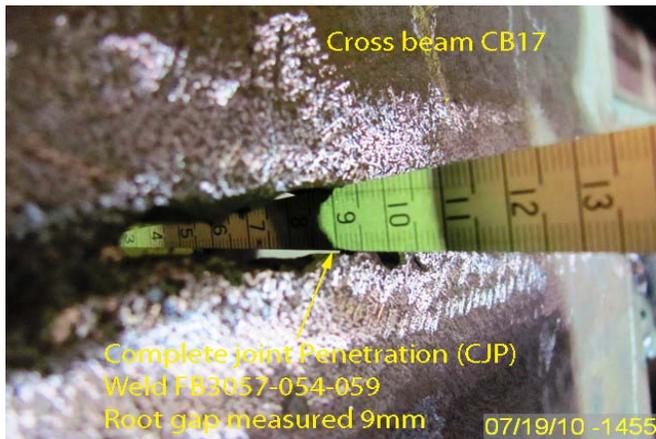
# WELDING INSPECTION REPORT

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documents.



## Summary of Conversations:

As mention above

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Sukanthan,Dhanasingh

Quality Assurance Inspector

**Reviewed By:** Hall,Steven

QA Reviewer